



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2650	REV. B SHEET 1 OF 7
DATE 97.06.26		TITLE 206/407 SKIDTUBE ASSEMBLIES SCALE NTS	
A	97.03.25	NEW ISSUE	
B	97.06.26	AS MANUFACTURED CHANGES	

RELEASED  
97/07/11 DS

UNDER REVIEW  
97/10/30 DS

SUPERCEDED BY  
97/11/06 DS  
REV. C

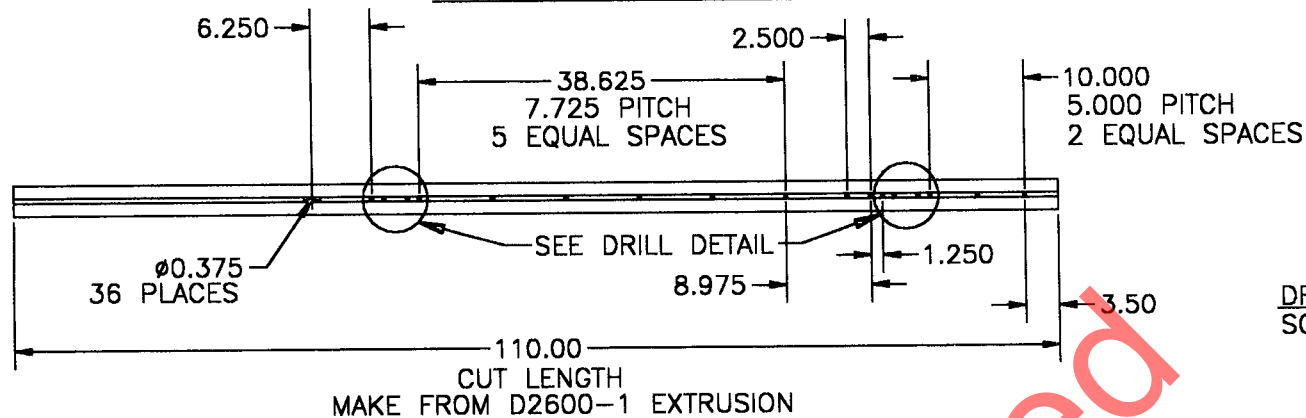
Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
*	*	*	*	D2600-1	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647-1	CAP
1	1	1	1	D2647-3	CAP
18	19	18	22	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
14	16	14	22	D2651-3	O-RING
2	2	2	2	MS27039-1-08	BOLT
42	44	54	60	ALS4-1032-130 or AKS7-1032-130	INSERT
2	2	2	2	AN960JD10L	WASHER

\* SEE DRAWING D2650 FOR CUT LENGTHS

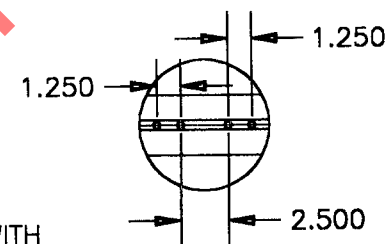
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
WELDING TO BE DONE PER DART QSI 004

DEO'S  
9077 97.08.21 DS 9082 97.09.29 DS

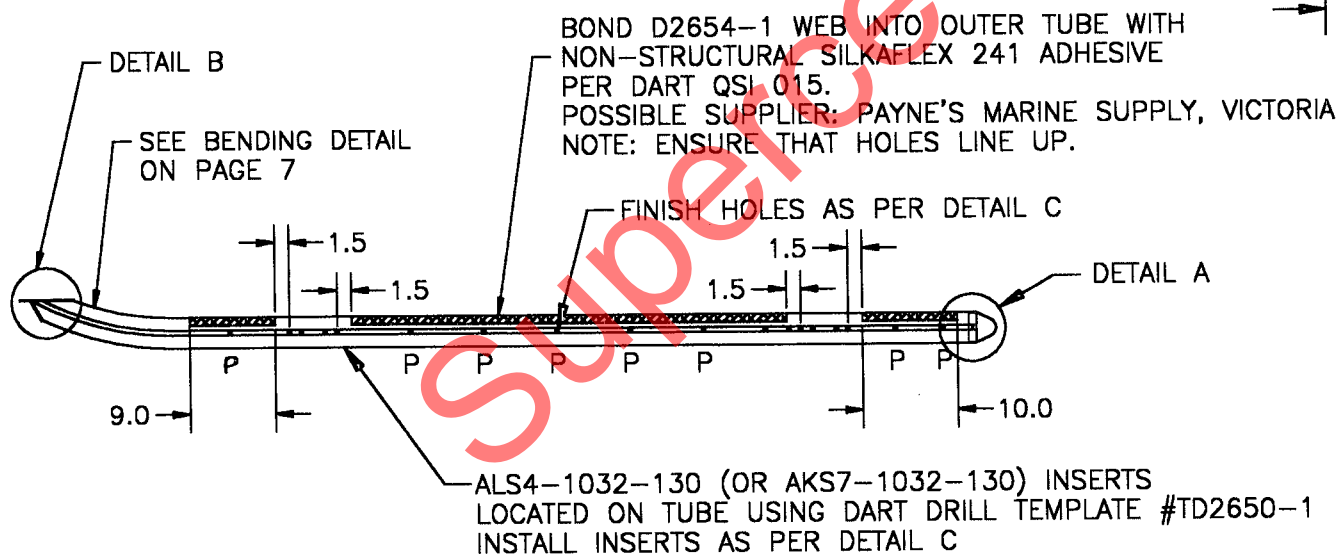
### D2650-1 DRILLING DETAIL



DRILL DETAIL  
SCALE 1:10



### D2650-1 FINISHING DETAIL



FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT PER DART QSI 005 4.3 OR PRIME, PAINT PER DART QSI 005 4.2  
BLACK ANTI SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4  
OR  
ACID ETCH, ALODINE PER DART QSI 005 4.1 AND PRIME PER DART QSI 005 4.2

NOTE: INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P'



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CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	TITLE	REV. B
97.06.26	206/407 SKIDTUBE ASSEMBLIES	SHEET 2 OF 7
		SCALE
		1:20

12.500  
6.250 PITCH  
2 EQUAL SPACES

2.500

38.625  
7.725 PITCH  
5 EQUAL SPACES

10.000  
5.000 PITCH  
2 EQUAL SPACES

5.50

1.250

8.975

120.00  
CUT LENGTH  
MAKE FROM D2600-1 EXTRUSION

Ø0.375  
38 PLACES

SEE DRILL DETAIL

DRILL DETAIL  
SCALE 1

DETAIL B

SEE BENDING DETAIL ON PAGE 7

BOND D2654-3 WEB INTO OUTER TUBE WITH NON-STRUCTURAL SILKAFLEX 241 ADHESIVE PER DART QSI 015.  
POSSIBLE SUPPLIER: PAYNE'S MARINE SUPPLY, VICTORIA  
NOTE: ENSURE THAT HOLES LINE UP.

FINISH HOLES AS PER DETAIL C

DETAIL A

1.5

1.5

1.5

P P P P P P P P

15.3

12.0

ALS4-1032-130 (OR AKS7-1032-130) INSERTS LOCATED ON TUBE USING DART DRILL TEMPLATE #TD2650-3  
INSTALL INSERTS AS PER DETAIL C

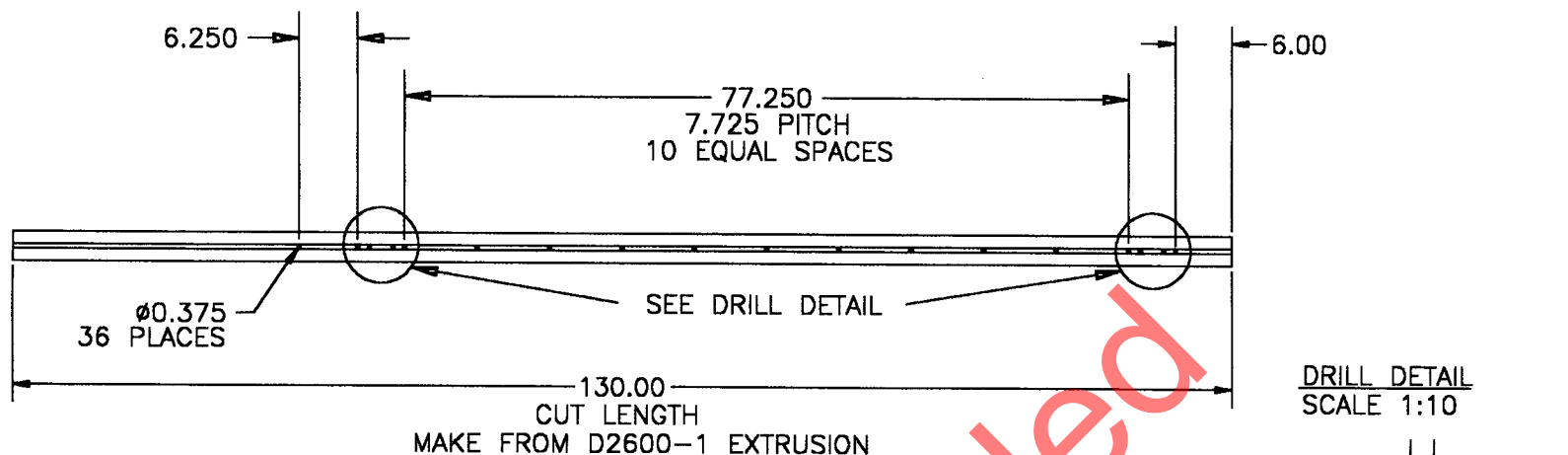
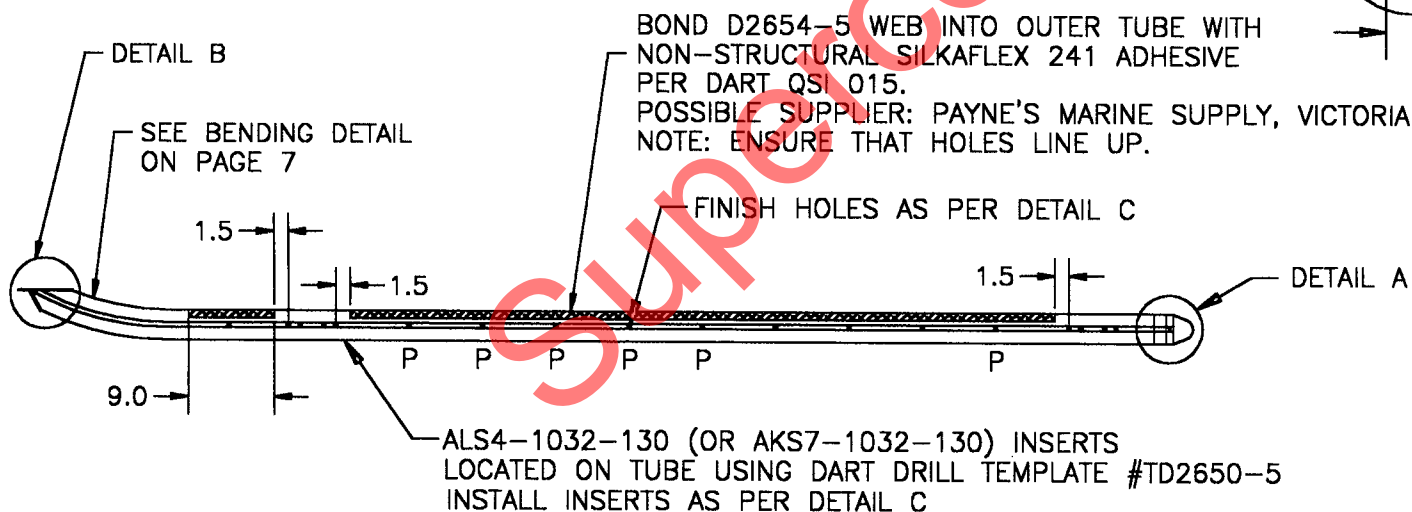
NOTE: INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P'

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**DART**



DESIGN <i>mev</i>	DYNAM BT <i>mev</i>	DART AEROSPACE USA., INC. FAIRCHILD INTERNATIONAL AIRPORT, WA		REV. B
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2650	SHEET 3 OF 7	
DATE 97.06.26		TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE 1:20	

D2650-5 DRILLING DETAILD2650-5 FINISHING DETAIL

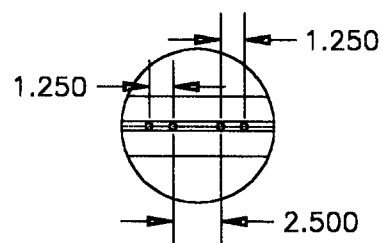
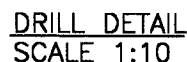
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT PER DART QSI 005 4.3 OR PRIME, PAINT PER DART QSI 005 4.2  
BLACK ANTI SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4  
OR  
ACID ETCH, ALODINE PER DART QSI 005 4.1 AND PRIME PER DART QSI 005 4.2

NOTE: INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P'

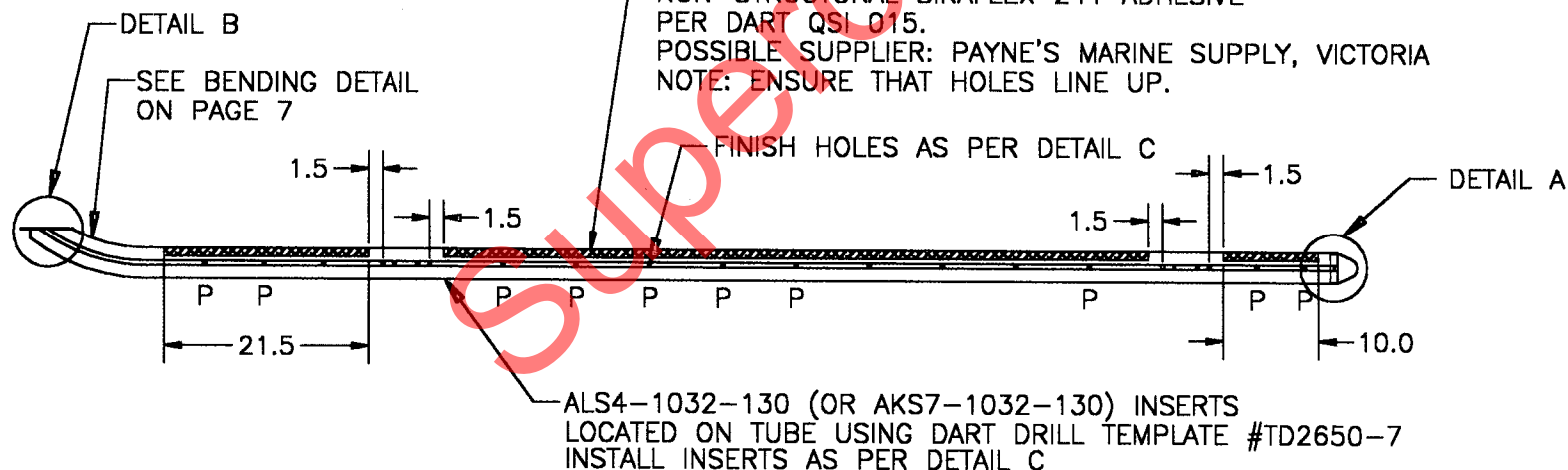
**DART**

DESIGN <i>DM</i>	DRAWN BY <i>DM</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	REV. B
CHECKED <i>DM</i>	APPROVED <i>DM</i>	DRAWING NO. D2650	SHEET 4 OF 7
DATE 97.06.26	TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE 1:20	

5.000 PITCH  
2 EQUAL  
SPACES  
← 10.000



BOND D2654-7 WEB INTO OUTER TUBE WITH  
NON-STRUCTURAL SIKAFLEX 241 ADHESIVE  
PER DART QSI 015.  
POSSIBLE SUPPLIER: PAYNE'S MARINE SUPPLY, VICTORIA  
NOTE: ENSURE THAT HOLES LINE UP.



FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT PER DART QSI 005 4.3 OR PRIME, PAINT PER DART QSI 005 4.2  
BLACK ANTI SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4  
OR  
ACID ETCH, ALODINE PER DART QSI 005 4.1 AND PRIME PER DART QSI 005 4.2

NOTE: INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P'

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DAV-37

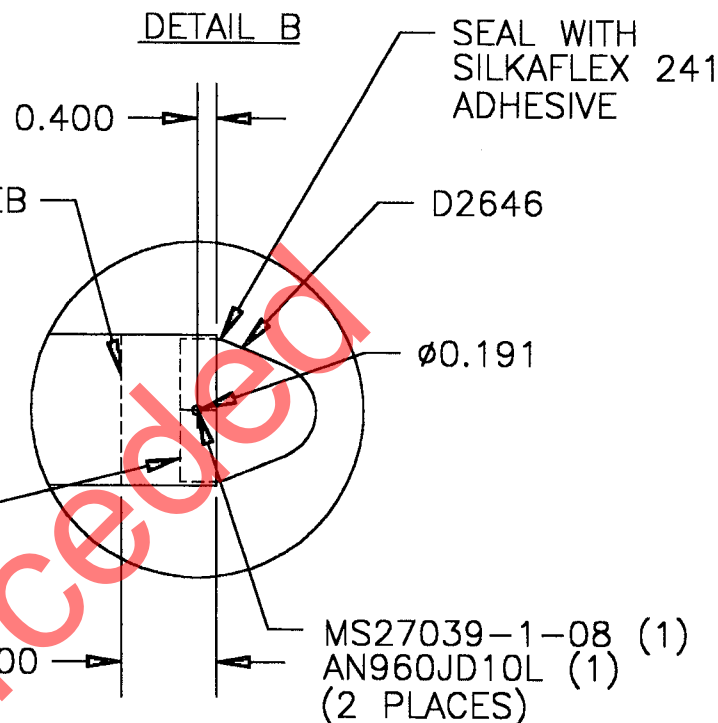
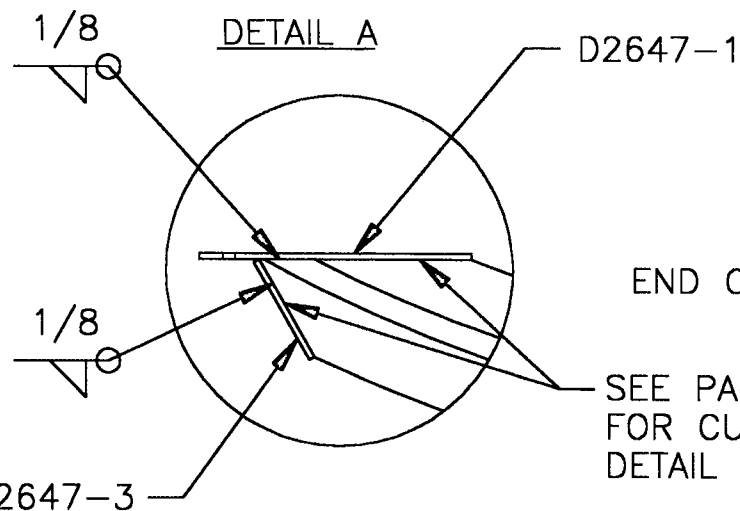


DESIGN <i>WMA</i>	DRAWING BY <i>WMA</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA
CHECKED <i>WMA</i>	APPROVED <i>WMA</i>	
DRAWING NO. D2650 SHEET 5 OF 7 REV. B		
DATE 97.06.26	TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE 1:20

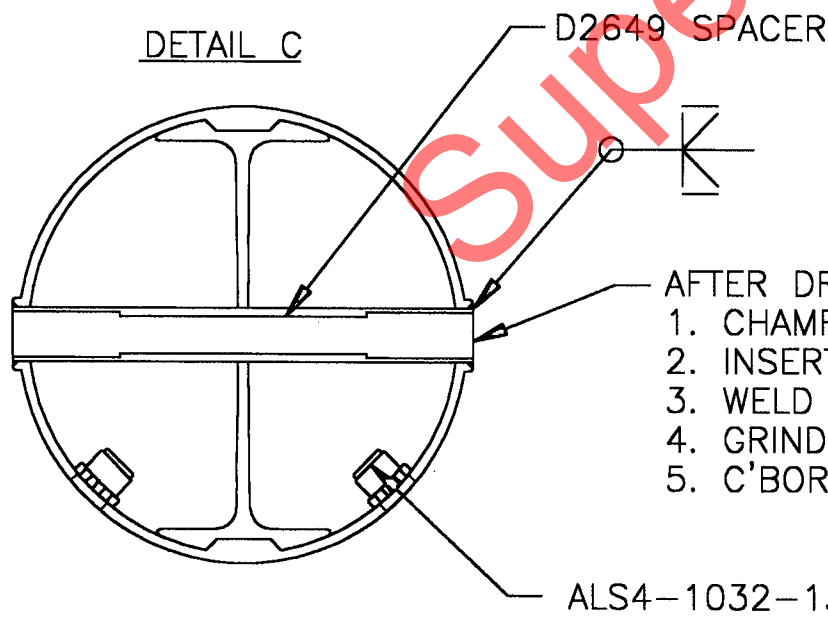
**DART**



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE	DRAWING NO.	REV. B
97.06.26	D2650	SHEET 6 OF 7
	TITLE	SCALE
	206/407 SKIDTUBE ASSEMBLIES	NTS



BORE OUT END OF SKIDTUBE  
TO 0.75 DEPTH AND 0.070 WALL

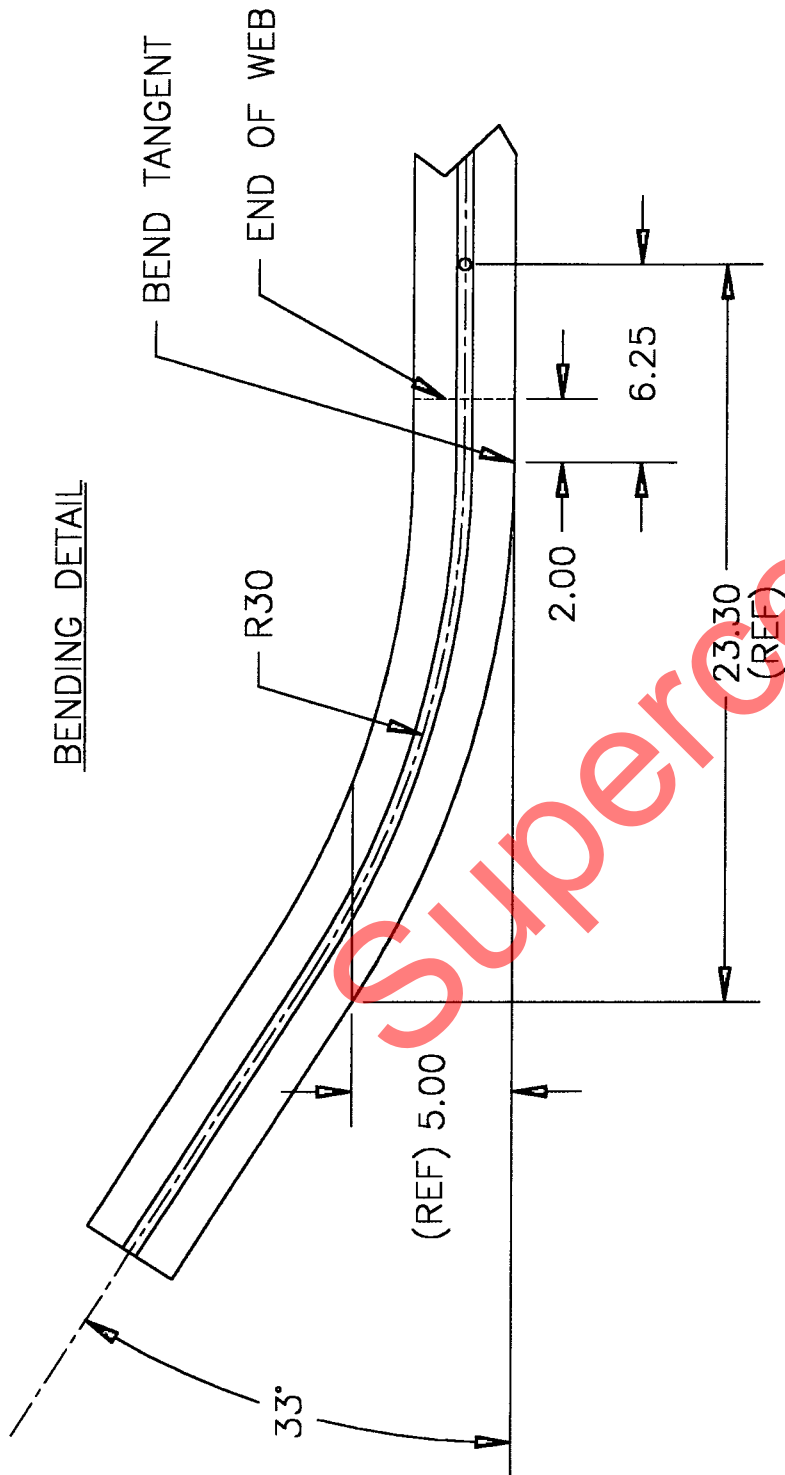


- AFTER DRILLING AND BENDING ASSEMBLY:
1. CHAMFER HOLE 0.030 X 45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE
  4. GRIND FLUSH
  5. C'BORE TO 0.313 DIA X 0.75 DEEP

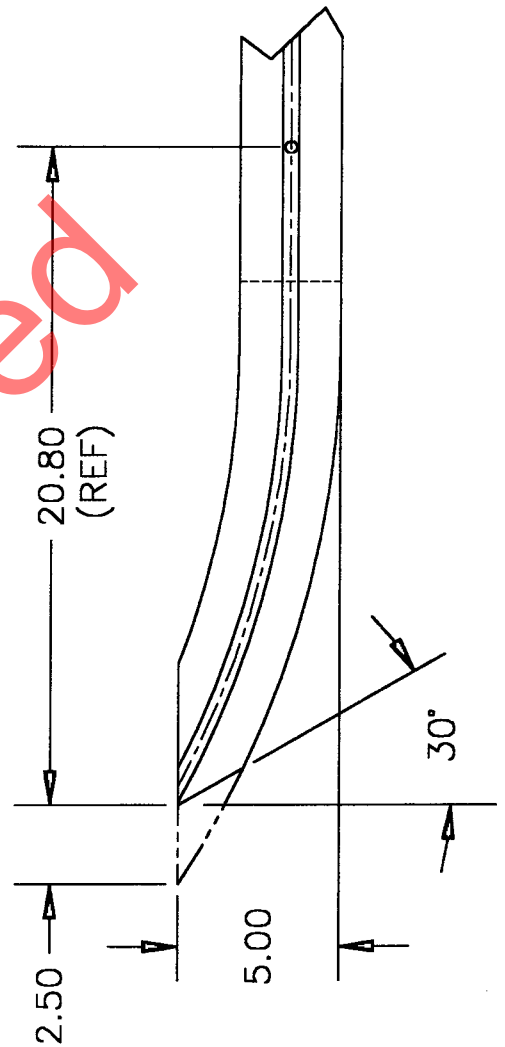


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2650	REV. B SHEET 7 OF 7
DATE 97.06.26		TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE 1:6

BENDING DETAIL



CUTTING DETAIL



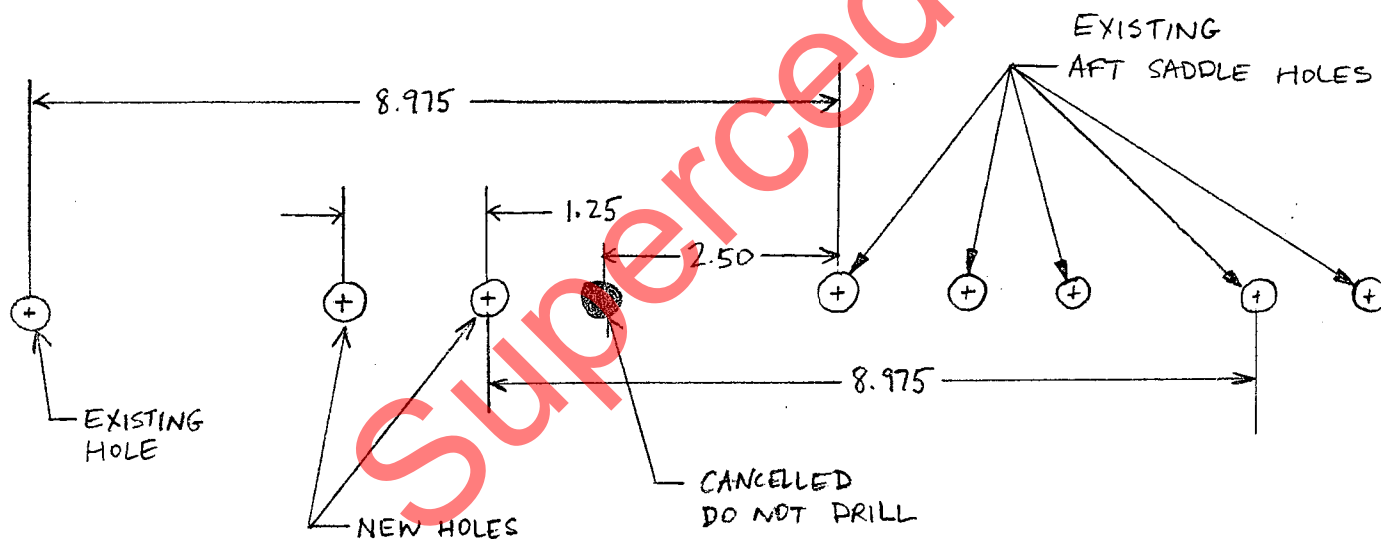
DESIGN DS	DRAWN BY DS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DEO 9077	REV. A SHEET 1 OF 1
DATE 97.08.21		TITLE 206 SKIDTUBE HOLE SPACING CHANGES	

## DART ENGINEERING ORDER

**RELEASED**  
97.08.21 DS

TO AMEND DWG : D2650 REV. B  
D2654 REV. B

THE HOLE PATTERN NEAR THE AFT SADDLE HOLES OF THE 206B TUBES (D2650-1 AND D2650-3) AND WEBS (D2654-1 AND D2654-3) SHOULD BE MODIFIED AS FOLLOWS :



D2650-1 WILL NOW REQUIRE 19 D2649 CROSS BOLT SPACERS  
D2650-3 WILL NOW REQUIRE 20 D2649 CROSS BOLT SPACERS